Friday, 6/1/2007 1:02:36 PM Kim Johnston User: **Process Sheet** : GASKET Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 32741 : 12719 **Estimate Number** : N/A : D353625 P.O. Number **Part Number** S.O. No. : NIA : D3536 REV A This Issue : 6/1/2007 **Drawing Number** : N/A Prsht Rev. : NC Project Number First Issue : SMALL /MED FAB **Drawing Revision** : NA : 32271 Previous Run Material : 6/8/2007 Qty: 20 Um: Each **Due Date** Written By Checked & Approved By Comment : Est Rev:A New Issue 07-02-14 JLM **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** NEOPRENE SHEET 0.063 1.0 MNEO60S063 12.5076 sf(s) Comment: Qty.: Total: 0.6254 sf(s)/Unit NEOPRENE SHEET 0.063 Batch: M 103104 WATER JE 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3536 ml or 06 02 Dwg Rev: 1 Prog Rev:_ 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 Comment: INSPEC PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK PACKAGING RESOURCE #1 5.0 PACKAGING ' Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Page 1

Dart Ae	rospac	e Ltd	, !	 							٠.	
W /O:			!	1	٧	VORK ORDER C	HANGES					
DATE	STEP		:	PROC	EDURE CI	HANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
			t t	 								
			! !	i ! !								
,												
Part No):;	7	PAR #:		_ Fault Ca	tegory:	NC	R: Yes	No DQA	: 🗊	Date: 🗸	1166/05
· · · · · ·	وم. د		' '	- "	r 3		•	QA: N	/C Closed	:	_ Date: _	
NCR:					ORK OR	DER NON-CON	FORMANCE	E (NCR)			
	0750	Des	cription of NC		L,	Corrective Action	Section B		Verifica	ation	Approval	Approva
DATE	STEP		Section A		Iñitial Chier≀Eng	Action Desc Chief En	ription	Sign & Date	Section		Chief Eng	QC Inspecto
			504		Ø				_			
July Salah	7		4						-		-	1.53
			م الم	,)(a							
,		!	7 				·				, · · · · .	٠ - س د م
•			· .	į.			the sales				NOV. N. J.	
		-			, 7		<	, ,				
		1	ا									
						·						je i
		1	}									1

NOTE: Date & initial all entries

Date: User: Friday, 6/1/2007 1:02:36 PM Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32741

Part Number: D353625

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21



FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C207/06/04

Dart Ae	rospace	e Ltd		!	ļ					هيست ند ڏ . د	-			# : 5 : ;
W/O:			· · · · · ·	,	į į	1	NORK OR	DER CH	IANGES		ser ⁱ		1	, , , -
DATE	STEP				PROC	EDURE C	HANGE			Ву	Date	Qty	'Approval' 'Chief Eng / 'Prod Mgr	Approv QC Inspect
														(A)
										e.k.		// \		
Part No):	4	**	PAR #:	<u> </u>	_ Fault Ca	ategory:			R: Yes	No DQ	A:	Date: _	
JAN'		:	•						2	QA: I	N/C Close	d:	Date: _	·
NCR:			1		W	ORK OR	DER NON	-CONFC	ORMANC	E (NCI	₹)	. 1	· · · · · · · · · · · · · · · · · · ·	
			Desc	ription of NO			Corrective	e Action	Section B		Verific	ation	Approval	Annroye
DATE	STEP			Section A	Ĭ 	Initial Chief Eng	Actio	on Descrip Chief Eng	otion	Sign a	Section Section		Chief Eng	Approva QC Inspecto
***				 					·					
			!											
				-	<i>,</i> ~ <		, ., .							
				 - - - -								1		

NOTE: Date & initial all entries

B

₽₹

DART

AEROSPACE PORT HADLOCK,

USA,

₹ C

Œ

DRAWING NO.

SHEET 1 OF 6

1:10 SCALE

06.

5 .25

GASKET NEW

 \triangleright

06,10,25

ISSUE

B. 62.12

-	- 26.65
	23.15
	21.15
	17.65
DETAIL A #0.19 (TYP 3 PLS)	13.40 9.15

D3536-11 GASKET

SHOP COPY URN TO JUT NOTICE **TERING** JLLED COPY AMENDMENT

뒾ડ

DOCUMENT

ឆ

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

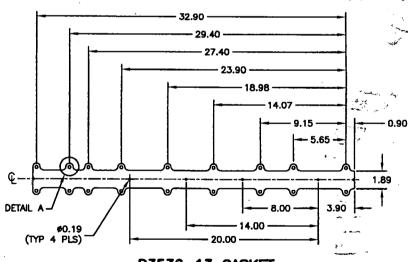
PURPOSE

욹

COPIED

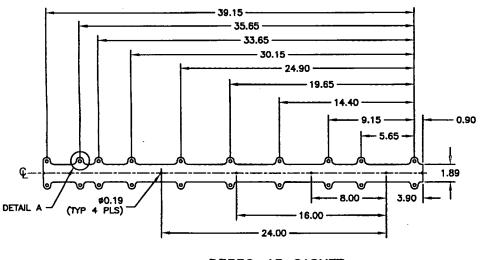
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-13 GASKET

07.02.12



D3536-15 GASKET

ci 'DP COPY TO AMENDMENT COPY COPY THE TO FRING

SE

DOCUMENT

ℴ

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

유

COPIED

- NOTES

 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 7) SEE PAGE 6 FOR DETAILS AND SECTION

	ļ -			— 3 2.70 —		
		· · · · · · · · · · · · · · · · · · ·	27.	.25		
		· · · · · · · · · · · · · · · · · · ·	21.80			<u> </u>
DETAIL A	5.45	16	35 —			0.90
€ <u> —</u> 2.00 —	6.00	8.0	0 — 16.00	- 24.00	•	#0.19 (TYP 4 PLS)

D3536-21 GASKET

1:10	GASKET		06.10.25
SCALE	חותב		DATE
SHEET 2 OF 6	D3536	¥	£
REV. A	DRAWING NO.	APPROVED []	CHECKED
PORT HADLOCK, WA		CB	4)
DART AEROSPACE USA, INC.	DART	DRAWN BY	DESIGN

東京 一角角



DATE

CHECKED

APPROVED C

D3536 DRAWING NO.

SHEET

3 OF SCALE 1:10

Ø

B

田

で型

DART

AEROSPACE

USA,

₹ C

PORT HADLOCK,

06.10.25

GASKET



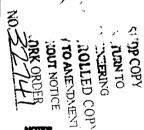
-DETAIL A

1.89

0.90

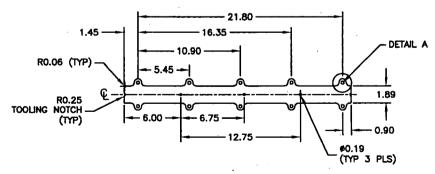
6.00 16.00 **9**0.19 (TYP 6 PLS) 24.00 32.00 39.00 48.00 D3536-23 GASKET

48.20



2.00

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- PART IS SYMMETRICAL ABOUT &
 TOLERANCES ARE PER DART QSI D18 UNLESS
 OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-25 GASKET

봀 DOCUMENT ß Copyright © 2006 by DART AEROSPACE USA, III PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART , **INC.** NOT TO BE USED FOR ANY I ART AEROSPACE USA, INC. PURPOSE 윘 COPIED



DATE 06.10.25 CHECKED B \mathcal{Z}

DRAWING NO. 量 DART AEROSPACE PORT HADLOCK, USA,

SHEET

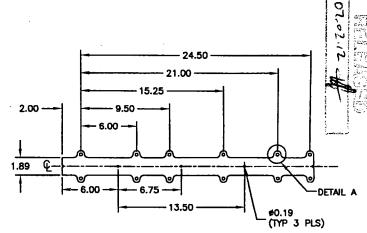
4 OF 6 SCALE 1:10

NC.

GASKET

22.50 19.00 2.00 ---6.00 -Q-1.89 DETAIL A ≠0.19 (TYP 3 PLS)

D3536-31 GASKET



D3536-33 GASKET

TANTE OF CONTROL BLACK NEOPRENE SHEET, 1/16 THICK, 60

NIPOMETER (PEF DART SPEC M-NEOPOS) 智

봀

DOCUMENT

 $\overline{\mathbf{s}}$ PRIVATE OR

Copyright © 2006 by DART AEROSPACE USA, INC.

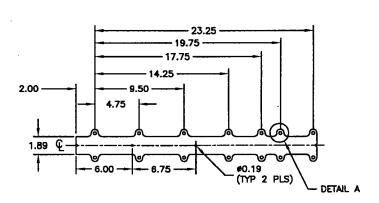
AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

윢

COPIED

- DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
 IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-35 GASKET

B

 Ξ

D3536

SHEET

5 약 SCALE 1:10

o

DRAWING NO.

DART

AEROSPACE PORT HADLOCK,

≸

RC.

06.10.25

GASKET

7.02.12

2.00 4.75 1.89 - 6.00 8.00 DETAIL A 21.00 ≠0.19 (TYP 4 PLS) D3536-37 GASKET

30.75

27.25

COPY 到 10113.

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEOSO-S.063)

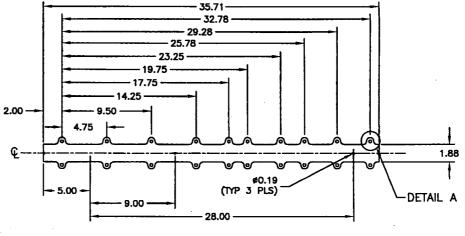
2) FINISH: NONE

3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-39 GASKET

뒾S DOCUMENT ᇙ Copyright © 2006 by DART AEROSPACE USA, IN PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART. INC.

NOT TO BE USED FOR ANY FART AEROSPACE USA, INC. PURPOSE 욹 COPIED



D3536-41 GASKET

¢0.19 (TYP 2 PLS) 1.88

27.98 25.08

18.50

2.00 -

4.00 -

DETAIL A

봀

DOCUMENT

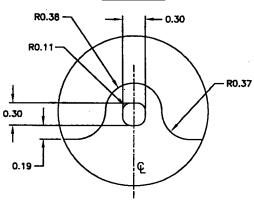
ភ

Copyright © 2006 by DART AEROSPACE USA, INC.
PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

DUROMETER (REF DART SPEC. M-NEUDU-S
2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER

DETAIL A



DESIGN B	DRAWN BY	DART	DART AEROSPACE USA, INC.	"USA,	INC.
CHECKED	APPROVED //	DRAWING NO.			REV. A
#	#	D3536		SHE	SHEET 6 OF 6
DATE		TITLE			SCALE
06.10.25		GASKET			1:10

DARIT; AEROSPACE LTD	Work Order:	3214
Description: Gaslet	Part Number:	D3536-25
Inspection Dwg: 03536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
-----------------	-----------

Inspection Sheet Tolerance Actual Dimension Accept Reject Method of Inspection Comments					<u> </u>			
B 21.80 +1-0.030 D.80 / Vim A C 0.19 +1-0.030 0.31 / Jan A D 0.30x0.30 +1-0.030 0.32x0.30 1 Jan A E F G G H I I J K L M N N O P Q R S T U V W W			Tolerance	l i	Accept	Reject		Comments
B 21.80 +1-0.030 D.80 / Vim A C 0.19 +1-0.030 0.31 / Jan A D 0.30x0.30 +1-0.030 0.32x0.30 1 Jan A E F G G H I I J K L M N N O P Q R S T U V W W	A	1.89	41-0.030	1.87	V		hmy	
C 0.19	8		+1-0.030		1			
D 0.30x0.30	C	1	+1-0.030	0. al	1		NOWN	
E	D	0.30x0.30		:	1		NWN	
G H H H H H H H H H H H H H H H H H H H	E							
H								
	G							
J K K I M I N I O I P I Q I S I T I Y I W I	H							
K Image: Control of the control of	ł		`					
L M M Image: Control of the con	J					:		
M N O O P O R S T U V W	K							
N	L							
O P	M							
P	N						<u> </u>	
Q Image: Control of the control of	0							
R S S S S S S S S S S S S S S S S S S S	р							
S	Q							
T	R							
V	S							
V W	Т							
w ·	IJ							
VV	٧							
X	W						•	
	X							
Y	Y							

Measured by:	met met	Audited by:	20	Prototype Approval:	N/A
Date	01 06 02	Date:	of 06.04	Date:	N/A
Rev Date	Change			Revised	by Approved
h	Manufacus			KURE	1 :

